

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015193**Date Inspected:** 22-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed no welding related being performed in Bay 10.

Bay 11

This QA Inspector randomly observed no welding related work being performed in Bay 11.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of various weld joints as a result of visual testing inside the OBG at PCMK 8BW/8CW on both sides of transverse joint, T-stiffeners to bottom plate, hold back welds. Welder was identified as 045246. QC was identified as ZPMC CWI Sha Zhi (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shen Jian Bo, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1.

FCAW welding of weld joint OBE9-008 located inside the OBG at PCMK 9BE/9CE, transverse joint. Welders were identified as 066881, 068501, 067993. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shen Jian Bo, who was not a CWI.

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Welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2231T.

Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lifts 2 were erect with south and east lifts 3 attached above, respectively. North tower, lift 3 had been placed atop north tower, lift 2 and appeared to still be attached to rigging from the floating crane moored to the foot of the heavy dock. West tower, lift 3 was laying horizontally at the foot of the dock and no ZPMC workers were present. ABF Representative Kang Yi acknowledged that no work was being performed on the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
